

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: VERTICAL TUNNEL L/H		
Job Number	: 43096			Part Number	: D38221		
Estimate Number	: 13585			Drawing Number	: D38221-UNDER REVIEW-08.11.10		
P.O. Number	:			Project Number	: IN0002		
This Issue	: 30/10/2008 S.O. No. :			Drawing Revision	: A UNDER REVIEW		
Prsht Rev.	: NC			Material	: MKYDEX6185S80P362015		
First Issue	: / / Type : R&D THERMOFORMING			Due Date	: 06/11/2008 Qty: 2 Um: Each		
Previous Run	: 42067						
Written By	:						
Checked & Approved By	:						
Comment	: Est. A New Issue 08/09/17 DL						

## PROTOTYPE

PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING

08/10/2008 DL

## Additional Product

Job Number:


Positive  
Recall
Cancel

Seq. #:	Machine Or Operation:	Description:	
1.0	MKYDEX6185S80P362015	Kydex velour matte, ivory	
		Comment: Qty.: 7.4028 sf(s)/Unit Total : 14.8056 sf(s) Kydex velour matte, ivory	
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Machine set up		08/11/03 DL
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
		Comment: HAND FINISHING THERMOFORMING	
	1) Cut sheet to required blank size		08/11/03 DL
4.0	THERMOFORMING	THERMOFORMING MACHINE	
		Comment: THERMOFORMING MACHINE	
		Thermoform as per Dwg. D3822-1 and folio (FTA 9073 Prototype ) using tool DT 9073	
	Dwg. Rev. <u>A UNDER REVIEW</u>		
	Folio Rev. <u>A</u>		
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		Visually inspect for proper formation of each part	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL L/H

Job Number: 43096

Part Number: D38221

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK

*108.11.27 (D)*

Comment: SECOND CHECK

7.0 HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

*108.11.27 (X2)*

8.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

9.0 QC5

INSPECT WORK TO CURRENT STEP

**ENGINEERING  
APPROVAL**

Comment: INSPECT WORK TO CURRENT STEP

*108.12.01*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*N/A*

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*10.08.12.01 Prototype*

Job Completion



*10.08.12.01*

~~POSITIVE RECALL~~  
~~EFFECTIVE 08.10.30 AUTH 11~~  
~~RELEASED~~  
~~DATE~~

*cancel 08.12.01*

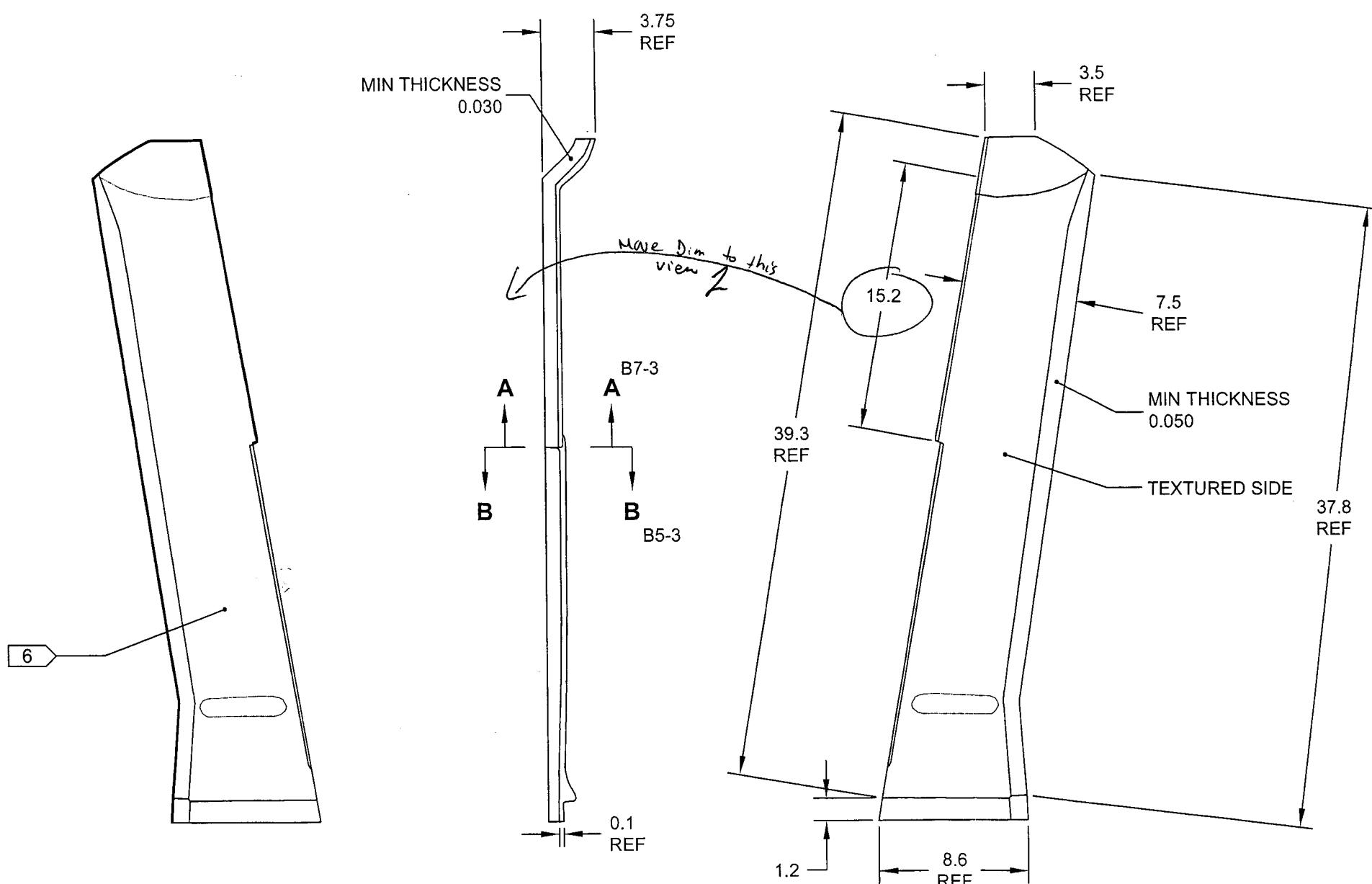
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3822-1 VERTICAL TUNNEL, LH

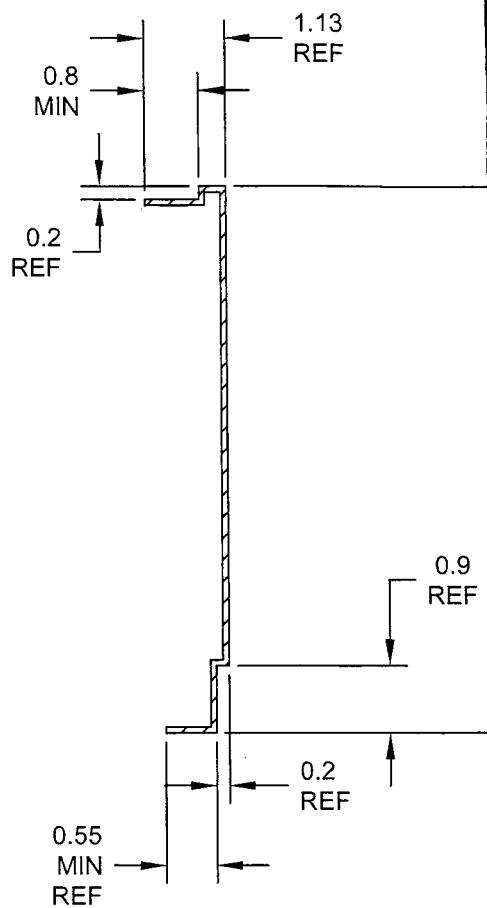
NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015  
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3822-1" USING VIBRATING STYLUS
- 7) WEIGHT: 1.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
03.11.10 P&A

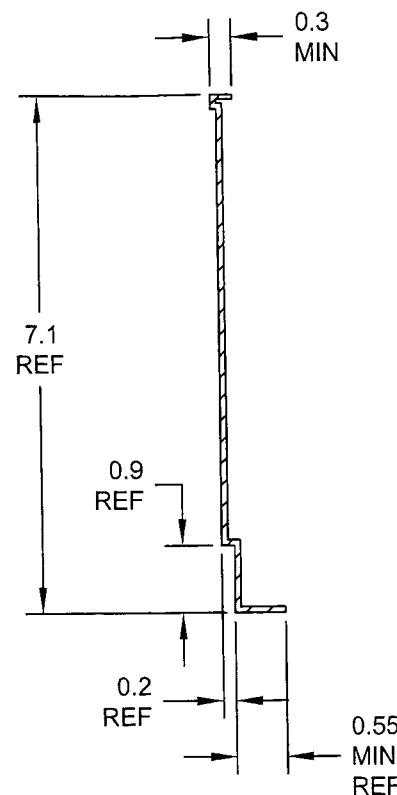
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	P&A	DART AEROSPACE LTD	REV. A
DRAWN	P&A	HAWKESBURY, ONTARIO, CANADA	SHEET 1 OF 6
CHECKED	P&A	DRAWING NO.	REV. A
MFG. APPR.		D3822	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL	NTS
DATE	08.09.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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SECTION A-A

C6-1



SECTION D-D

C4-2

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
03.11.10 pbf

<i>pb</i>	DART AEROSPACE LTD		
<i>pb</i>	HAWKESBURY, ONTARIO, CANADA		
<i>pb</i>	DRAWING NO.	REV. A	
	D3822		SHEET 3 OF 6
<i>pb</i>	TITLE	SCALE	
	VERTICAL TUNNEL		NTS
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## Receiving Report

**Dafni**

**Supplier:**

Packing Slip: Yes  No   
Invoice: Yes  No   
Receipt: Cash  Cr

Batch No: 27109703

Dart P/O: 7280

Release Note Attached: Yes  No  N/A   
Waybill Attached: Yes  No  N/A   
Shipment Complete: Yes  No  N/A   
QC6 Inspection 05/10/17  N/A   
Work Order  N/A

## Discrepancies

Discrepancies						
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

## Administrator

### Location



**SABIC Polymershapes**

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3  
TEL: 613 745 7043 FAX: 613 745 8163

## **CERTIFICATE OF COMPLIANCE**

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER: 7280

OUR SHIPPER NO: 084287

LINE ITEM #: 1

QUANTITY: 51

54 *Sab* 084287

*S*  
084287

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS  
OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE  
PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND  
LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

*Jon Caldwell*

JON CALDWELL  
BRANCH MANAGER

DART AEROSPACE LTD	Work Order:	43096
Description: Vertical tunnel LH / Prototype	Part Number:	D3822-1
Inspection Dwg: D3822 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____ "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/11/27

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.75 (Ref)		3.75	✓			
0.030	Min	0.035	✓			
0.1	± 0.100	0.180	✓			
39.3 (Ref)		39.3	✓			
15.2	± 0.100	15.23	✓			
1.2	± 0.100	1.20	✓			
7.5	± 0.100	7.5	✓			
0.050	Min	0.057	✓			
39.3 (Ref)		39.325	✓			
37.8 (Ref)		37.8	✓			
8.6 (Ref)		8.6	✓			

Measured by: BB

Date: 08/11/27

Audited by: BB

Date: 08/11/27

Prototype Approval: BB

Date: 08.12.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	